J. P. Sauer & Sohn gegründet 1751

SAUER 303

S303

Handling and Safety Instructions

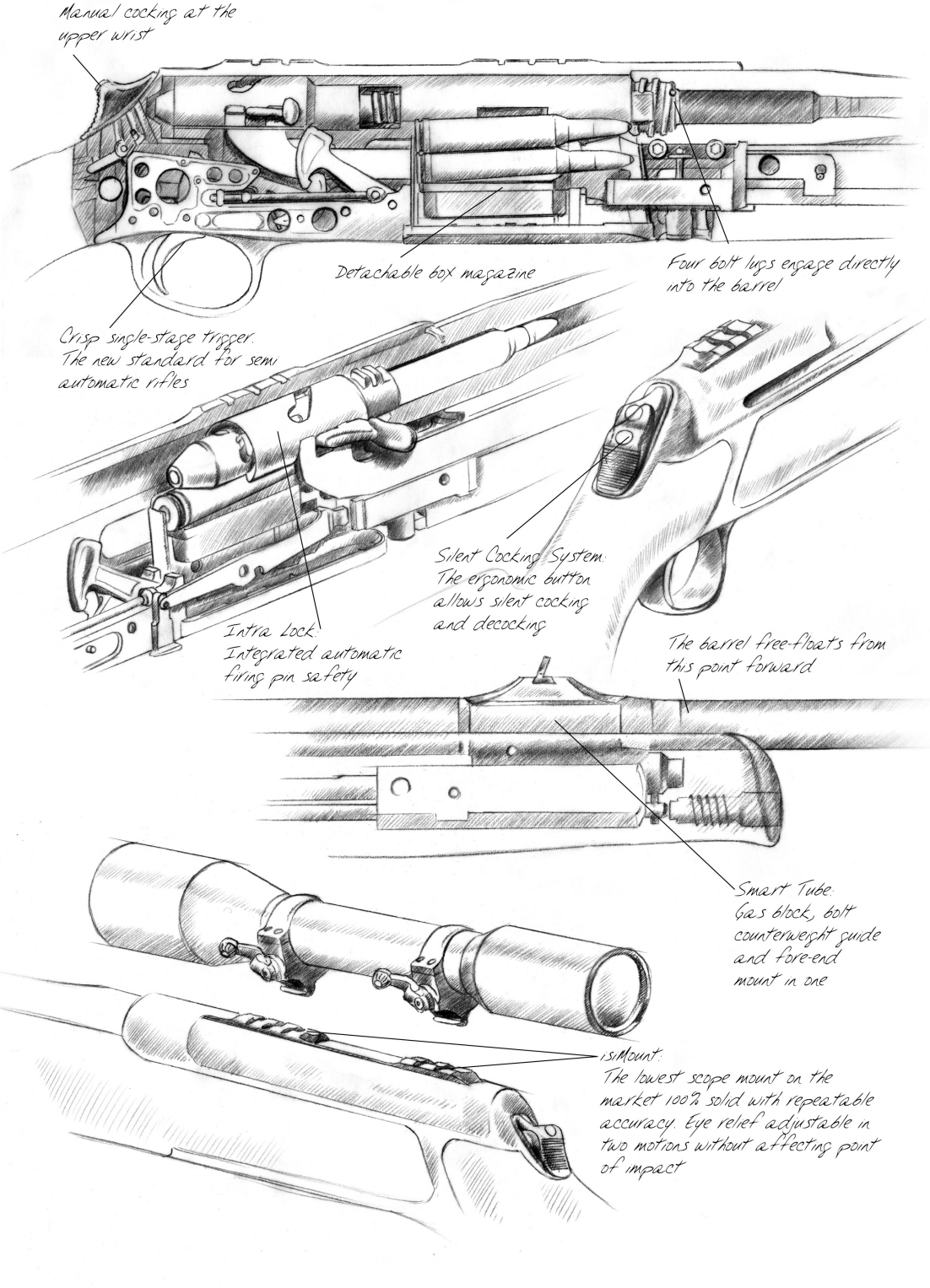
S 303

New Dimensions

S 303 – superior technology, luxurious craftsmanship, perfected styling.

Leading innovations from the field now set new standards in safety, function and accuracy. Logical operations and perfect control combine for hunting success. The styling is testament to the sportsman's passion for the hunt and the result is a superior hunting rifle with the heart of a SAUER.

- A receiver milled from a solid block of metal is at its foundation. All other component parts are of modular design.
- The manual cocking feature on the upper wrist provides a premium on safety in any situation. All manual operations for loading, unloading and magazine removal as well as closing or opening the breech may be performed while the gun is decocked.
- The "IntraLock" firing pin safety engages automatically if the breech is not 100 % in battery.
- Soldered or screwed-on barrel blocks are not necessary for gas management. Additionally, the automatic loading sequence cannot influence barrel vibrations since the forward part of the barrel is fully free-floating. The S 303 has inherited the accuracy for which SAUER is famous.
- The single-stage trigger sets new standards in its class. Creep is minimal and the shot breaks at 1,300 g like glass. With this unparalleled performance, the S 303 does as well from the blind as from the stand.
- The proprietary "isi-Mount" is perfectly tailored to the needs of today's hunter. With a 100 % repeatable point of impact after removal, it puts the scope lower than ever before and only two motions are needed to adjust the eye relief by ca. 1 cm.
- The contrasting open sights consist of a triangular yellow rear blade and a red front bead which instinctively lead the eye to the target. The front sight is click-adjustable for windage and elevation. The optional Battue rib with its long sight line helps you make those tough snap shots.
- Snow, rain, cold and a pile of thorns – "NITROBOND X" is the new steel surface treatment that scoffs at the elements. Two elaborate plasma treatments ensure uncompromising protection against rust and scratching.


Manual cocking at the upper wrist
Detachable box magazine
Four bolt lugs engage directly into the barrel
Crisp single-stage trigger. The new standard for semi automatic rifles
Silent Cocking System. The ergonomic button allows silent cocking and decocking
Intra Lock. Integrated automatic firing pin safety
The barrel free-floats from this point forward
Smart Tube. Gas block, bolt counterweight guide and fore-end mount in one
ISI Mount. The lowest scope mount on the market 100% solid with repeatable accuracy. Eye relief adjustable in two motions without affecting point of impact

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1 General instructions

Be sure to read through these instructions carefully before any manipulation on this SAUER gun.

Understanding these instructions and the technically correct implementation of the information contained therein are **imperative** for the correct preparation and safety during handling, maintenance and care of this SAUER gun. Do not use the gun until you have fully understood all safety instructions and handling procedures. Should you require further information, do not hesitate to contact your dealer, importer or the manufacturer.

Please observe the local and national legislation governing the ownership, carrying and use of firearms.

Be aware that this gun, like all firearms, is dangerous. The gun accompanying these Handling and Safety Instructions has been sold under the express understanding that the manufacturer and the importer of the gun decline any responsibility for consequences of manipulations on the gun or use of the gun. This applies in particular to liability for bodily harm or damage to property resulting in part or in whole to:

– use with criminal intent or negligent use,
– improper or careless handling,
– defective, incorrect, hand-charged or recharged ammunition,
– inadequate care of the gun (e.g. corrosion, damage),
– disregard of malfunctions,
– resale in contradiction of regional legislation and regulations, other circumstances beyond our direct and immediate control
– other circumstances beyond our direct and immediate control.

These limitations apply regardless of whether liability is asserted on the basis of contract, negligence or strict liability (including any failure to warn).

The manufacturer and the importer are not liable for incidental or consequential damages such as loss of use of property, commercial loss or loss of earnings and profits.

2 Safety regulations

- Never use the gun under the influence of alcohol or drugs, during illness or other complaints; they may influence your judgement and reflexes.
- Always treat the gun as loaded and unlocked until you have made sure to the contrary by unloading it.
- During all manipulations, keep the muzzle of the gun pointed in a safe direction. Safe directions are defined as areas where there are no people, other living creatures or other people's property.
- Never point the gun at doors, window panes, walls, concrete, stones or other flat surfaces (including water). Shots can penetrate such surfaces or be deflected into unsafe directions by them.
- Never aim at yourself or other people.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Always handle your gun as if the safety mechanisms were not functional. The best safety device is the correct, well-exercised and secure handling of the gun.

- Never shoot a gun into which there has been ingress of water, sand, dirt or other foreign bodies.
- Never release the tension on the firing pin merely by pulling the trigger.
- Never let a loaded gun out of your hands.
- Always unload the gun immediately after shooting, before putting it down, putting it in its case or handing it to another authorised person.
- Never hand the gun to any person who has not thoroughly familiarised himself or herself with the safety regulations and handling of the gun by reading the accompanying instructions.
- Never leave the gun lying around unattended. Unauthorised persons can cause damage or threaten or kill people with it, for which you might be liable.
- Never store the gun loaded, but remove the magazine and verify through unloading there is no round in the barrel chamber.
- Never store the gun together with the ammunition and verify that both is not accessible for unauthorised persons and children.

2.1 Safety instructions

In the individual sections of these instructions, the following safety indications alert you to various risks:

	WARNING!
Information on risks which, if not scrupulously observed, can lead to severe bodily harm or death.	

	CAUTION!
Information on risks which, if not scrupulously observed, can lead to bodily harm or damage to the gun.	

	CAUTION!
Information on technical requirements which, if not scrupulously observed, can lead to damage to the gun.	

- Each safety indication consists of:
  - a header with a signal word, icon and a corresponding colour shading
  - a specification of the type and source of the risk
  - a specification of potential consequences if the safety indications are not observed
  - specifications of measures and prohibitions designed to avoid risks

3 Product description

3.1 Main parts

3.1.1 Version with removable magazine

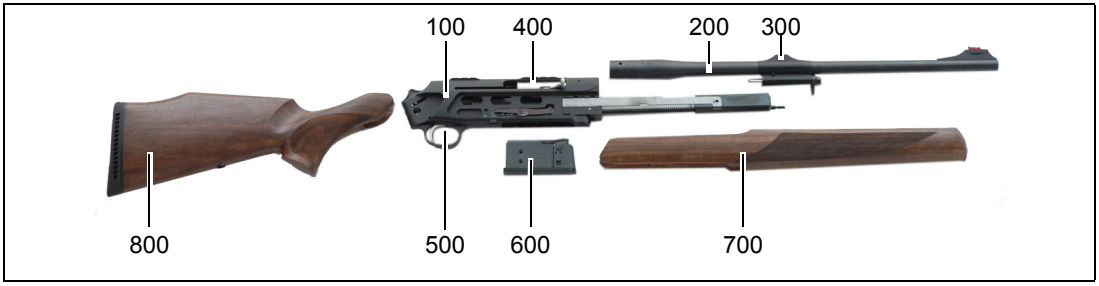

Fig. 1 Figure with closed slide

Item	Description	Item	Description	Item	Description
100	Magazine tube	400	Slide	700	Front stock
200	Barrel	500	Trigger mechanism	800	Main stock
300	Gas chamber with sights	600	Magazine		

3.1.2 Version with fixed fold out cover magazine

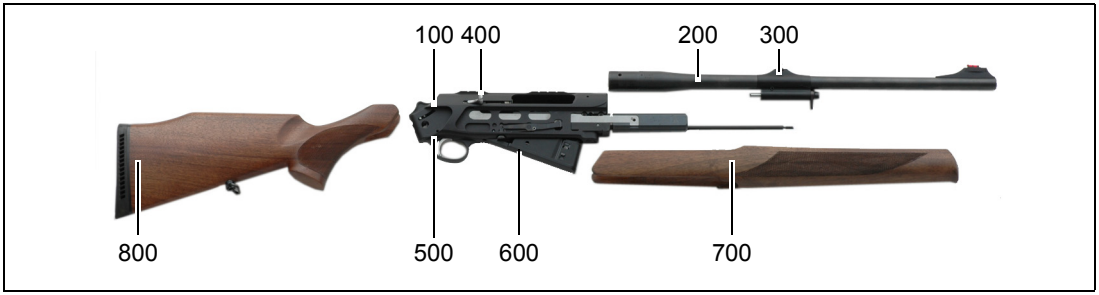

Fig. 2Figure with open slide

Item	Description	Item	Description	Item	Description
100	Magazine tube	400	Slide	700	Front stock
200	Barrel	500	Trigger mechanism	800	Main stock
300	Gas chamber with sights	600	Spring magazine		

3.2 Main features

The SAUER 303 is a high precision hunting rifle built to the latest technology. It is a self-loading rifle with manual clamping mechanism and flint trigger that is simple and safe to operate.

The housing is prepared for the installation of the new SAUER telescopic sight **isiMount**. In addition the modular design allows the installation of various main stocks, as well alternative rear sight devices or optical sight correction.

The SAUER 303 is also available with left-hand stocks, so that by its ability to be operated from both sides and the controlled case ejection, which is oblivious to left-hand shooters, a "real" left hand gun is made available.

3.3 Scope of delivery

The standard scope of delivery includes:

– 1 x gun
– 1 x magazine
– 1 x special socket spanner (2 parts)
– 1 x Torx spanner to dismantle the front stock and barrel.
– 1 x Handling and Safety Instructions manual
– 1 x 10 g SAUER Premium gun grease
– 1 x SAUER plastic case
– 1 x Warranty card

Fig. 3, Standard scope of delivery in plastic case

4 Transporting the gun

4.1 Transport in assembled state

Procedure:

1. Decock the gun (see section 6.2).
2. Remove / open the magazine and empty if necessary (see section 5.8.1).
3. Unload the gun (see section 5.6).
4. For models with fixed fold out cover magazine, close the empty magazine (see section 5.8.2).
5. Remove the sling attachment if necessary (see section 7.1).
6. Clean the gun (see section 11).

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- For your own safety and for the safety of others, always transport the gun in the unloaded condition (see section 5.6), and decocked.
- Never carry a cocked gun which is already cocked and contains a round in the barrel chamber.
- Always carry the gun in such a manner that, should you fall or otherwise slip, you are able to control the direction of the muzzle.
- Transport the gun separate from the ammunition in a locked carrying case.
- The gun and ammunition must not be accessible to children and other inexperienced or unauthorized persons.
- Ensure that you comply with all regional and national laws relating to the transport of firearms.

4.2 Transport in the compact case

Procedure:

1. Decock the gun (see section 6.2).
2. Remove / open the magazine and empty if necessary (see section 5.8.1).
3. Unload the gun (see section 5.6).
4. For models with fixed fold out cover magazine, close the empty magazine.
5. Remove the sight correction (see section 9.2).
6. Remove the sling attachment (see section 7.1).
7. Clean the gun (see section 11).
8. Remove the main stock (see section 7.2).

5 Handling the gun

5.1 Preparing the gun

Note:
The gun is supplied with a protective and preserving oil and grease coating, and excessive protective oil and grease must be removed prior to first commissioning.

The SAUER 303 is supplied in a shock-proof durable plastic case.

For safety reasons the magazine must not be installed or flipped in during:

– first commissioning and

– taking possession of the gun.

WARNING!

Undefined condition of the gun
May lead to death or severe injuries

- If the shooter takes possesion of the gun in any other condition it must be treated as loaded.

Procedure:

1. Unload the gun (see section 5.6).
2. Check whether ammunition is still in the barrel chamber or in the magazine.
3. Clean the barrel (see section 11.2).
4. In addition during first commissioning:
   – Clean external metal surfaces (see section 11).
5. If supplied in compact case:
   – Fit the main stock (see section 8.2).

5.2 Ammunition

WARNING!

Incorrect ammunition
May lead to death or severe injuries and damage to the gun

- For your gun, use only commercial grade ammunition in the original packaging, which corresponds to the caliber of the gun.
- Only use high quality brand ammunition in your gun. Only then is problem-free function and precision guaranteed.
- Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your gun.
- Never use ammunition with steel shells or other shell material besides brass.
- Never use dirty, wet, corroded, bent, damaged or oiled ammunition.
- Never spray lubricants, preservatives or cleaning agents directly onto the rounds.
- Never leave the ammunition lying around unattended.

5.3 Loading the gun (ready to fire)

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Never load or unload the gun inside a vehicle, inside a building or any other confined space (except in a designated firing range).
- Before loading, always wipe off any excess grease and oil and check that there is no obstruction in the bore of the barrel.
- Always keep the muzzle of the gun pointed in a safe direction.
- Do not place your finger onto the trigger tongue, but outside the trigger guard.
- Do not load the gun by inserting the magazine until immediately before shooting.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Never let a loaded gun out of your hands.

5.3.1 Loading from the magazine

Procedure:

1. Decock the gun (see section 6.2).
2. Remove/open magazine (see section 5.8.1/ 5.8.2).
3. Open slide (see section 5.7.1).
4. Fill the magazine (see section 5.8.3).
5. Install magazine or close (see section 5.8.1/ 5.8.2).
6. Close slide (see section 5.7.2).

The gun is loaded and ready to fire.

5.3.2 Loading from your hand

Procedure:

1. Decock the gun (see section 6.2).
2. Remove/open magazine (see section 5.8.1/ 5.8.2).
3. Open slide and lock (see section 5.7.1).
4. Hold the gun with the muzzle pointing down.
5. Slide the round through the ejector window in the barrel chamber.
6. Close slide.

The gun is loaded and ready to fire.

Fig. 4

5.3.3 Silent loading

Procedure:

1. Depending on the procedure, complete Steps 1 to 5 from section 5.3.1 or 5.3.2.
2. Close slide silently (see section 5.7.3).

5.4 Discharging a shot

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Ensure that the target and the environment allow shots to be fired without danger.
- When discharging shots, ensure that your hands or any other parts of the body are located in front of, over or adjacent to the barrel muzzle or the ejection port.
- Never allow other persons to stand beside you where they might be struck by ejected cartridge cases.
- Always wear ear protection and safety glasses when shooting. Alert bystanders to the importance of wearing ear protection.
- Immediately stop shooting and unload the gun if you suspect that a round has not been chambered properly, a case is jammed, a bullet is lodged in the bore or a discharge sounded or felt weak or abnormal.
- Never attempt to dislodge a blockage in the barrel by firing another round.

Procedure:

1. Aim the gun at a safe target.
2. Cock the gun (see section 6.1).
3. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot.
4. Keep the gun aimed at the target and fire further shots as required.
5. If the magazine is empty, reload the gun (see section 5.5).
6. Uncock the gun and unload (see section 5.6).

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- If you decide to end the shooting session, immediately uncock and unload the gun.

5.5 Reloading during shooting

WARNING!

Insufficient awareness of the dangers
May lead to death or severe injuries

- Never let the gun out of your hands.
- Keep the gun pointed at the safe target.

Procedure:

1. Decock the gun (see section 6.2).
2. Remove or open the empty magazine (see section 5.8.1/ 5.8.2).
3. Fill the magazine (see section 5.8.3).
4. Install or close full magazine and check the catch (see section 5.8.1 / 5.8.2).
5. Close the slide.

The gun is loaded and ready to fire.

5.6 Unloading the gun

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- Never let the gun out of your hands before it is unloaded.
- The gun is loaded, a round is located in the chamber of the barrel.
- Never place your hand over the ejection port of the bolt.

Procedure:

1. Decock the gun (see section 6.2).
2. Aim the gun at a stop-butt.
3. Remove or open the magazine (see section 5.8.1/ 5.8.2).
4. Open slide (see section 5.7.1) and lock.
   – The cartridge is pulled out of the barrel chamber and ejected.
5. Check that the round has been ejected and there are no more rounds in the barrel chamber.
6. Empty magazine.
7. Pick up ejected round and clean the gun.

WARNING!

Gun has not been cleaned sufficiently
May lead to death or severe injuries and damage to the gun

- The gun must be cleaned after every shooting session (see section 11).

The gun is unloaded.

5.7 Slide

WARNING!

Gun is ready to fire
May lead to death or severe injury

- The gun must be decocked before every manipulation on the slide!

5.7.1 Open slide

Procedure:

1. Decock the gun (see section 6.2).
2. Remove/open magazine (see section 5.8.1 / 5.8.2).
3. Hold loading lever **416**.
4. Pull the slide straight back out until the stop (see Fig. 5).
5. Hold the slide tight and pull the slide lock **106** down.

Fig. 5

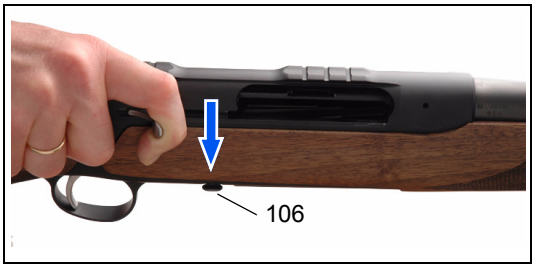

Fig. 6

5.7.2 Close the slide

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- The gun must be unloaded.

1. Decock the gun (see section 6.2).
2. Remove/open magazine (see section 5.8.1).
3. Press slide lock.

CAUTION!

Possible injury or damage to the gun

- Never move the slide towards the front if there is a finger or foreign object in or in front of the ejection window!
- Never use force to close the slide.

5.7.3 Closing the slide silently

In some situations it can be an advantage to close the slide silently.

Procedure:

1. Decock the gun (see section 6.2).
2. Remove/open magazine (see section 5.8.1 / 5.8.2).
3. Hold the loading lever tightly.
4. Press slide lock.
5. Move the slide slowly forward until it stops.
6. Push the slide forward with the loading lever until it is completely locked (see Fig. 7).

Fig. 7

5.8 Magazine

The SAUER 303 is available in two versions:

1. Version with removable magazine
2. Version with fixed fold out magazine (so called FM model)

5.8.1 Version with removable magazine

Removing the magazine

	CAUTION!
Magazine may fall out **Magazine may be damaged** • When removing the magazine always keep your hand exactly underneath the magazine.	

1. Press the stud with the pointer finger **107**.
2. Remove magazine.
3. Empty magazine.

Fig. 8

Inserting the magazine

Procedure:

1. Insert the magazine into the magazine shaft and push upwards until the magazine engages audibly. Do not jam the magazine.

5.8.2 Version with fixed fold out magazine

Open magazine

Procedure:

1. Press the stud with the pointer finger **107**.
2. Open magazine downwards.
3. Empty magazine.

Fig. 9

Inserting the magazine

Procedure:

1. Open magazine upwards, until the magazine audibly catches.

5.8.3 Loading the magazine

Procedure:

1. Push the rear feeder down.
2. Push the round from the front under the magazine lip.

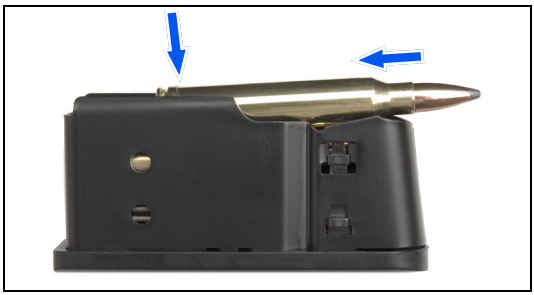

Fig. 10

5.9 Trigger

An adjusted flint trigger suitable for use is available for the SAUER 303.

5.9.1 Rifle trigger

Note:

- The trigger weight has been set to approx. 13 N (1300 g) at the factory.

The flint trigger is a direct trigger with a design dependent minimum stage.

– The shot is fired after the resistance has been overcome.

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- The weight of the flint trigger must not be changed for safety reasons.

5.9.2 Sights

Depending on the selected model, the SAUER 303 is supplied with various sight devices. In each case the gun is shot in the factory with open sight at 50 meters. A subsequent change of the sight device is possible.

5.9.3 Height adjustment of the sight

Procedure:

1. Place the correct 1.5 mm WAF Allen key in the screw on top of the front sight ramp before the front sight (see Fig. 11).

- Turn the screw with click-stop clockwise: Front sight moves higher, firing sits lower.
- Turn the screw with click-stop counter-clockwise: Front sight moves lower, firing sits higher.

Fig. 11

5.9.4 Side adjustment of the sight

Procedure:

1. Place the correct Allen key in the front screw on the front sight base.
2. Loosen screw and move the front sight to the desired position.
3. Retighten screw.

Alternatively, the side adjustment can be also be done on the rear sight (only with normal rear sight slide, not with hunting track Battue) (see Fig. 12).

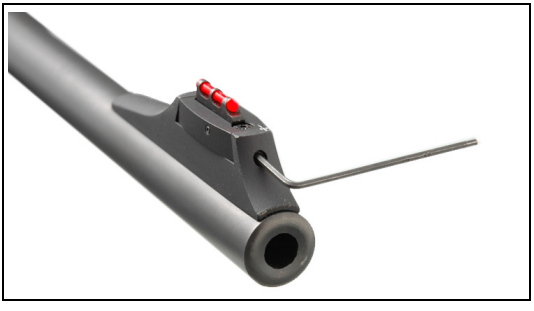

Fig. 12

Procedure:

1. Loosen the slotted screw on the rear sight ramp with the proper screwdriver
2. Move the rear sight to the side as desired.
3. Retighten screw (see Fig. 13).

Fig. 13

6 Hand cocking

The SAUER 303 is equipped with a manual hand cocker on the stock handle. This enables the marksman to cock the lock of the gun right before discharging a shot. In decocked condition the mainspring is relaxed, it is impossible to fire a shot.

Along with the manual hand cocker, to be operated by the marksman, the SAUER 303 additionally has an internal firing pin safety lock **intraLock**, which automatically activates if the slide is not completely locked. Because of this a discharged shot is impossible with a gun that is not completely locked. The safety lock **intraLock** can not be actively influenced by the marksman.

The cocking slide is found easily, both visually and by touch, above on the handle of the stock. The modern **Silent Cocking System SCS** allows the cocking cycle to be made without making disturbing noise.

Fig. 14

Fig. 15

Fig. 16

6.1 Cocking the gun

Procedure:

1. Lay the thumb of the ribbed surface of the cocking slide **116** so that the tip of the thumb half covers the cocking slide pin **117** (see Fig. 15).
2. Press the cocking slide forward to the stop.
3. Lift the tip of the thumb so that the cocking slide pin **117** leaves the cocking slide silently (see Fig. 16).
4. Remove the thumb from the cocking slide.

Note:
Gun cocked:

– Red point on the stock handle under the cocking slide is visible.

– Cocking slide pin **117** protrudes visibly and by touch out of the cocking slide (see Fig. 16).

6.2 Decocking gun

Procedure:

1. Lay the thumb on the ribbed surface of the cocking slide**116** so that the tip of the thumb half covers the cocking slide pin **117** (see Fig. 15).
2. Press the cocking slide slightly forward and simultaneously press in the cocking slide pin **117** with the tip of the thumb (see Fig. 15).
3. Move the cocking slide slowly backwards.
4. Remove the thumb from the cocking slide.

Note:

Gun decocked:

– Red point on the stock handle under the cocking slide is not visible.

– Cocking slide pin **117** is level with cocking slide.

7 Dismantling

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun, ensure once again that it is unloaded (see section 5.6).

7.1 Removing the sling attachment

Procedure:

1. Firmly press in the spring bolt.
2. Turn the sling attachment gently and pull out.

Fig. 17, rear sling attachment bushing

Note:

- Clean and oil the sling attachment regularly.

7.2 Removing the main stock

Procedure:

1. Remove the sling attachment (see section 7.1).
2. Unscrew the main stock screw in the hole of the main stock **800** counter-clockwise using the long end of the special spanner supplied.
3. Remove the main stock by pulling downwards.

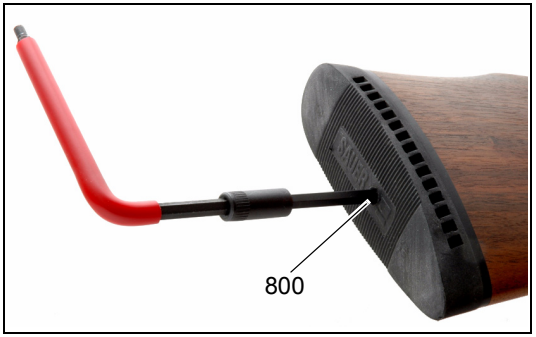

Fig. 18

7.3 Front stock removal

Procedure:

1. Remove the sling attachment (see section 7.1).
2. Insert the special Torx spanner with the short end through the sling attachment bushing **702**.
3. Turn the front stock screw with the special spanner clockwise until the resistance at the spanner disappears.
4. Remove the front stock **701** by pulling it to the front.

Fig. 19

7.4 Barrel removal

Procedure:

1. Remove/open magazine (see sections 5.8.1 / 5.8.2).
2. Open slide and lock (see section 5.7.2).
3. Remove the front stock (see section 7.3).
4. Loosen the clamping screws with the supplied Torx spanner **102** by approx. a half turn, however do not remove.
5. Turn the Torx spanner **102** with the long end in opening between the two screws until the stop, so that the housing is slightly pryed open.
6. Remove the barrel **201** from the housing **100**.

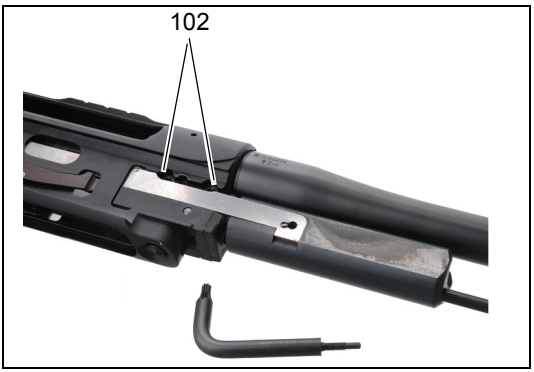

Fig. 20

Fig. 21

8 Assembly

	CAUTION!
Gun may be damaged	
• Only assemble cleaned gun parts.	
• Only tighten the screws for the stock attachment by hand (only operate the special spanner with two fingers), (see Fig. 23).	

8.1 Fitting the barrel

	CAUTION!
Gun may be damaged	
• Do not use force when inserting the barrel into the magazine tube.	
• Tighten the screws only so tight as is possible with three fingers.	
• The spanner must not be extended by attaching a tube.	
• When using a torque spanner tighten the screw to 5 Nm.	

Procedure:

1. Turn the Torx spanner **102** with the long end in opening between the two screws until the stop, so that the housing is slightly pryed open (see Fig. 21).
2. Push the barrel **201** up to the stop in the housing so that the spring guidance rod **113** comes through the provided opening under the gas cylinder housing (see Fig. 22).
3. Twist the torx-spanner completely out of the housing.
4. Alternatively, tighten the clamping screws **102** a little more until the barrel is held without tension (alternative: tightening with a torque spanner: torque 5 Nm).

Fig. 22

Note:

After every barrel removal and installation a test shot is necessary.

8.2 Fitting the main stock

Corresponding figure, see Fig. 18.

1. Slide the main stock onto the gun.
2. Hand-tighten the main stock screw clockwise with the long end of the special spanner supplied (approx. 5 turns).
3. Fit the sling attachment (see section 8.4).

8.3 Fitting the front stock

Corresponding figure, see Fig. 23.

Procedure:

1. Slide the front stock **701** onto the gun and press the sides of the front stock into the sides of the magazine tube.
2. Hand-tighten the front stock screw clockwise with the short end of the special Torx spanner supplied. If you are using a torque wrench, the tightening torque should be 3 Nm.
3. Fit the sling attachment (see section 8.4).

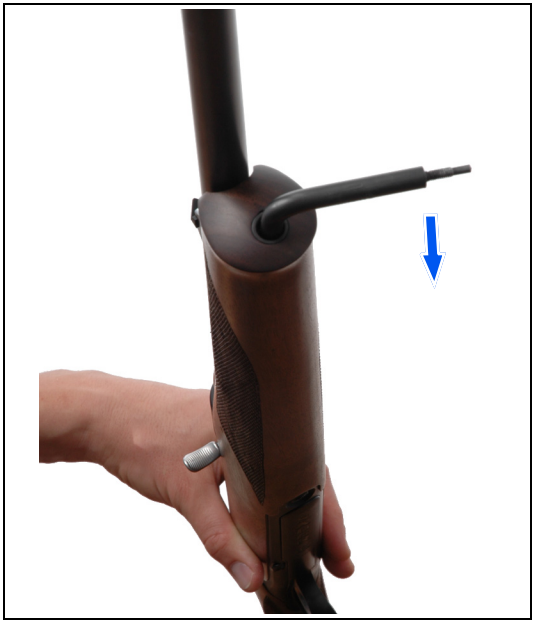

Fig. 23

8.4 Fitting the sling attachment

Corresponding figure, see Fig. 17.

Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **808**.
2. Press in the spring bolt.
3. Gently turn the sling attachment until the bolt safety lock engages.
4. Insert the bolt of the front sling attachment into the front sling attachment bushing **702**.

Note:

- The sling attachment must be aligned exactly 90° to the orientation of the barrel.
- The bolts must protrude clearly above the edge of the sling attachment body.

9 Mounting telescopic *isi-Mount*

	CAUTION!
Gun may be damaged	
•	Do not use force when putting on and taking off the telescopic sight.

The housing of the SAUER 303 is already prepared for the mounting of the new SAUER telescopic sight "isi-Mount“ (individual, selective, integrated) (see Fig. 24).

Fig. 24

This new mount guarantees the lowest design type, highest shot strength and absolute repeatability after taking off and putting on the telescopic sight. In addition the glass can always be mounted with the proper spacing due to the availability of 3 grooves in the front area of the housing.

Also the glass can be moved from the front to the rear groove (or opposite) without point of impact relocation. In this way the marksman can adjust the eye distance to the current conditions or his clothing thickness.

9.1 Putting on the telescopic sight

Procedure:

1. Lift up the locking lever of the mounting upper section and turn counter-clockwise.
2. Guide the telescopic sight slanted from the side into the housing grooves, so that the cross ribs of the mounting upper section lies congruent with the desired groove.
3. Tip the telescopic sight in the housing grooves.

4. Turn the locking lever with the thumb counterclockwise until the stop.
5. Fold down the locking lever frontwards (in firing direction).

Fig. 25

9.2 Removing telescopic sight

	CAUTION!
Gun may be damaged	
• When taking off the telescopic sight, the hand must always be placed on the telescopic sight so that it is held after loosening the mounting and does not fall.	

Procedure:

1. Lift out the locking lever of the mounting surface towards the rear (opposite to firing direction).
2. Turn the locking lever counter-clockwise to the stop.
3. Tip the telescopic sight to the side upward from the housing grooves.

Fig. 26

9.3 Changing eye distance

1. Remove telescopic sight (see section 9.2).
2. The telescopic sight is to be set on the housing so that the rear mounting top section is congruent with the other of the two back grooves.
3. Set on telescopic sight (see section 9.1).

Fig. 27

For mounting other than is described here, the J.P. Sauer & Sohn GmbH takes no guarantee for function and shooting performance.

10 Extras

10.1 Hunting track - Battue

For instinct shooting using the open sight, the hunting track -Battue is offered which can be retrofitted on every SAUER 303.

Procedure:

1. Remove front stock (see section 7.3).
2. Remove the barrel (see section 7.4).
3. Unscrew the slotted screw on the sight base in front of the rear sight and slide the rear sight out of the base from the side (see Fig. 28).

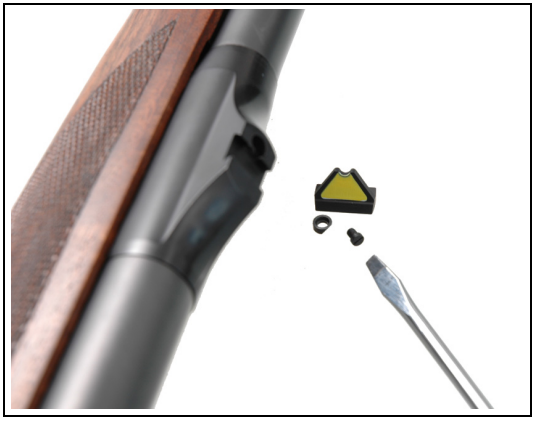

Fig. 28

4. Slide the hunting track in the base from the side and attach using the screw on front of the track with the correct
   SW 1.5 mm Allen key (see Fig. 29).

Fig. 29

5. Mount the barrel (see section 8.1). Be careful that the rear end of the hunting track enters the groove of the housing (see Fig. 30).

Fig. 30

6. Shoot the gun using the open sight (see section 5.9.2).

11 Care

11.1 General

Proper functioning and precision of the gun can only be maintained through regular and expert care. The gun must be cleaned and protected against corrosion after each use. The bore must be cleaned and protected against corrosion after each firing. The slide and the slide rail must always be cleaned and lightly lubricated after each firing. Wooden stocks must be treated with a suitable agent in accordance the corresponding instructions and must be protected against the weather.

For the optimum care for your SAUER 303 we recommend SAUER care products, e.g. the SAUER Premium gun grease.

For a normal cleaning it is sufficient to remove or dismantle the following gun parts:

- Magazine
- Rifle sling

If the gun has been exposed to extreme moisture or is heavily soiled, it is recommended to remove or dismantle the following gun components:

- Magazine
- Telescopic sights
- Rifle sling
- Main stock
- Front stock

WARNING!

Gun is ready to fire
May lead to death or severe injuries

- There must be no magazine in the gun.
- Before stripping your gun for cleaning, ensure once again that it is unloaded (see section 5.6).

11.2 Cleaning the barrel

CAUTION!

Gun may be damaged

- Never clean the barrel from the front with a cleaning chain or a steel cable and do not use steel or brass brushes, because these will damage the surface of the barrel. Use a suitable cleaning string or the proper cleaning rod and brush of the proper calibre.
- Detergents can damage the surface of the gun. Read the manufacturer's indications and warnings before using solvents or cleansers.

Procedure:

1. Unload the gun (see section 5.6).
2. Open slide (see section 5.7.1).
3. Slide the cleaning string with a brush of the proper calibre through the ejection window in the barrel and pull it from the muzzle through the barrel.
4. When the barrel is removed clean from behind with a suitable cleaning rod.
5. Basically use only suitable cleaning agent, oil or grease.
6. Check whether deposits of the rounds have collected in the sections. If necessary, clean the barrel with a commercial grade barrel cleaning agent (observe the respective instructions for use) designed for firing residue.
7. Coat the barrel bore and the barrel chamber with a little gun oil or gun grease.
8. **With installed barrel:** Rub the barrel bore and barrel chamber dry by pulling through a suitable cleaning string several times.
9. **With dismounted barrel:** Rub the barrel bore and barrel chamber dry from behind with a plastic sheathed cleaning rod of the proper calibre.

11.3 Cleaning the slide

Proper functioning of SAUER 303 is only guarenteed when the slide and its rail are always maintained absolutely clean and lightly lubricated.

- Open slide (see section 5.7.1).
- Clean everything accessible through the ejection window with a clean cloth.
- Clean locking head and base with a clean cloth.
- Thinly apply appropriate gun oil to the surface of the slide rail.
- Close the slide (see section 5.7.2).
- Apply few drops of oil on the slide cover in the ejection window.
- Open and close the slide several times in order to achieve an optimum lubrication.

Attention: Only a small amount of oil is required to obtain perfect function. Too much oil can lead to malfunction and to impairment of precision.

11.4 External metal and wood surfaces

For the care and preservation of the external metal and wood surfaces we recommend SAUER Premium gun grease. Minute spherical Teflon® particles seal the pores of all wood and metal surfaces and provide perfect protection and optimal sliding characteristics.

Benefits:

- dry surfaces - dust etc. does not adhere;
- water and salt water proof;
- absolute corrosion protection;
- perfect sliding characteristics, reduced wear;
- resistant to sweaty palms;
- pressure resistant up to 57.000 kg/cm^2;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel and wood;
- neutral smell;

	CAUTION!
Gun may be damaged	
• Caring for the external metal surfaces is particularly important in wet weather or if the metal surfaces have come into contact with sweaty body parts.	
• Always wipe dry the gun prior to preservation.	

Procedure:

1. Thoroughly clean the gun using suitable cloths and cleaning agents.
2. Thinly apply the grease with a cloth or sponge over the whole gun (including the stock) including all mechanical and moveable parts.
3. After a reaction time of at least 60 minutes wipe dry and polish the gun with a clean cloth.
4. Dependent on the weather and frequency of use the protective effect will last between two to six months.

Note:

- The sling attachments must also be cleaned regularly and their locking mechanism oiled.
- So-called "water stains" on the stock after rain cannot be avoided. Depending on the calcium content and dust and dirt particle content of the rain water, this phenomenon is stronger or weaker. It is not a defect in the stock finish.

12 Dealing with problems

12.1 Cause and correction of malfunctions

Gun maintenance (cleaning and inspection) according to the instructions can prevent malfunctions.

Should, nevertheless, a malfunction occur during shooting, proceed as follows:

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- Hold the gun pointed in the firing direction (safe direction) and keep your finger off trigger tongue while you carry out the steps described below.

1. Decock gun.
2. Remove magazine or open (see section 5.8.1) and dispose of safely.
3. Open slide and lock.
   – The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
4. Check that no bullet, round, cartridge case or foreign matter is in the barrel chamber or barrel. If a projectile is lodged in the bore, strip the gun (see section 7) and have the blockage removed with a suitable tool by a qualified gunsmith.
5. Remove all rounds, cases or foreign bodies. Clean, lubricate and assemble the gun (see section 11 and 8).
6. Have the gun inspected by an armourer or gunsmith.

Fault	Potential cause	Remedy
No round chambered.	Magazine not properly inserted or closed, deformed or dirty.	Insert magazine completely until catch or close (see section 5.8.2).
	Gun faulty.	Repair by manufacturer.
Gun is loaded and cocked. When trigger is pulled, no shot is fired.	Gun is not completely unlocked.	Close slide completely (see section 5.7.2). Pull cocking slide manually back and cock again.
Gun does not advance a new round automatically or clamps it tight.	Gun is not held properly in the shoulder.	Decock the gun (see section 6.2). Open slide (see section 5.7.1). Load new round. Pull gun tight into the shoulder.
	Gun faulty.	Repair by manufacturer.
Gun decocks automatically when firing.	When cocking the bolt for cocking slide (117) did not emerge completely out of the cocking slide.	When cocking the cocking bolt for cocking slide must emerge completely out of the cocking slide.
Cocking slide is in front position, when trigger is pulled no shot is fired and no cut off of the hammer.	Gun is not decocked.	Pull cocking slide back until it engages audibly. Then cocking according to handling and safety instructions.
	Gun faulty.	Repair by manufacturer.

12.2 Shipping the gun

Note:

- Familiarize yourself fully with regional legislation governing the shipping and transportation of firearms.

Procedure:

1. Check the gun to ensure that it is unloaded and decocked.
2. Pack the gun well (if possible in its original packaging) to prevent damage in transit. To prevent the gun being recognised as such during shipping, wrap the original packaging in a second outer layer. Do not include any accessories in the shipment.
3. Enclose a letter stating the following:
   - your full name
   - your full address (state street, not P.O. Box)
   - your daytime telephone number
   - model and serial numbers of the gun
   - detailed description of the problem encountered or the service work to be performed.
4. Send the gun properly insured and carriage-paid (packages without correct postage will not be accepted) to:
   - the sales outlet from which you purchased the gun
   - the local Sauer & Sohn dealer,
   - the Sauer & Sohn agent (importer) for your country
   - if there is no local appointed Sauer & Sohn dealer or Sauer & Sohn agent in your country, to J.P. Sauer & Sohn GmbH.

13 Technical Specifications

Functional principle	Self loading rifle/gas pressure loader
Action type	Rotary bolt lock, locking in barrel
Calibre	**Medium:** 7x64; .30-06; 8x57 IS; 9.3x62 **Magnum:** .300 Win. Mag.
Length, overall	approx. 1065 mm (with barrel length 510 mm) approx. 1115 mm (with barrel length 560 mm)
Barrel length	**Medium:** 510, 560 mm **Magnum:** 510, 560 mm
Stock length (Monte Carlo stock)	approx. 355 mm
Stock indentation (Monte Carlo stock); from top edge of magazine tube	**Front:** 32 mm **Center:** 25 mm **Back:** 50 mm
Stock offset	5 mm
Trigger weight	approx. 13 N - 15 N
Magazine content	**Medium:** 2 rounds **Magnum:** 2 rounds
Replacement magazine	**Medium:** 5 rounds / 2 rounds **Magnum:** 5 rounds / 2 rounds Magnum:
Weight without telescopic sights, 510 mm barrel length and Monte Carlo stock.	**Medium:** approx. 3,25 kg **Magnum:** approx. 3.25 kg

Subject to change without notice

14 Accessories

Your SAUER 303 is a modular hunting gun which can be easily adapted to new uses at a later date. The complete and current option selection and individual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage (www.sigsauer.de). There you will also find all telescopic sight assemblies, replacement magazines, sights and any other gun accessories.

In addition Sauer & Sohn offers the following accessories for the perfect transport and stylish presentation of your gun and for successful hunting: More precise information can be found in the catalogue or on the internet at (www.sigsauer.de).

15 Spare parts

J. P. Sauer & Sohn GmbH only supplies to authorised dealers in Germany or to the respective SAUER importer abroad. For ordering spare parts please always contact your dealer who will then forward your order accordingly to the importer (abroad) or Sauer & Sohn (Germany). To enable the speedy and focused processing of your order please always provide the following information when ordering spare parts:

– Model, caliber, barrel length, extras
– Gun number
– Item number from the spare parts list

Designation of the desired spare part

15.1 Version with removable magazine

Item designation

100 Housing assembly
101 Housing, aluminum
102 2 clamping screws
103 Slide catch lever
104 Leaf spring f. slide catch
105 Lock f. slide catch
106 Magazine catch
107 Bolt for magazine catch
108 Locking pin
109 Ball
110 Pressure spring
111 Spring bolt
112 Insert with anti-squeal plate
113 Reverse recoil plug
114 2 straight pins
115 Action spring
116 Cocking slide
117 Bolt for cocking slide
118 Pressure spring
119 Heavy adapter sleeve
120 Straight pin
121 Bolt for barrel position
122 Spring for magazine ejection
123 Light dowel pin
124 Color insert, red

200 Barrel assembly
201 Barrel
202 Housing for gas cylinder
203 Heavy adapter sleeve
204 Bearing
205 Butt
206 Closing collet
207 Spring collet
208 Pan head screw

300 Rear & front sight assemblies
301 Aligning rear sight
302 Adjustable front sight

Item designation

303 Pan head screw

400 Slide assembly
401 Locking head
402 Extractor
403 Firing pin spring
404 Firing pin
405 Ejection rod
406 Ejector pin pressure spring
407 Bolt
408 Control bolt
409 Safety lock
410 Safety lock pressure spring
411 Control sleeve
412 2 slide rods
413 Slide weight
414 Slide lock
415 Cover sleeve
416 Loading lever
417 Clamp for weight

500 TriggerAssembly
501 Trigger housing
502 Latch
503 3 straight pins
504 Trigger
505 Safety lever
506 3 straight pins
507 Spring bolt
508 Magazine retaining spring
509 Hammer
510 Straight pin
511 Cocking lever
512 Bolt for hammer
513 2 spring bolts for mainspring
514 2 mainsprings
515 Bolt for chain
516 2 nuts
517 2 chains 36.7 mm
518 2 chains 16.3 mm

Item designation

600 Magazine assembly
601 Magazine case
602 Engaging piece for slide catch
603 Magazine spring
604 Feeder
605 Magazine floor plate

700 Front stock assembly
701 Front stock
702 Sling attachment bushing
703 Nut
704 Retainer ring

800 Main stock assembly
801 Main stock
802 Pan head screw
803 Washer
804 Crown gear
805 Retention sleeve
806 Butt
807 2 rounded head screw
808 Sling attachment bushing
809 Flat head wood screw
519 Pin

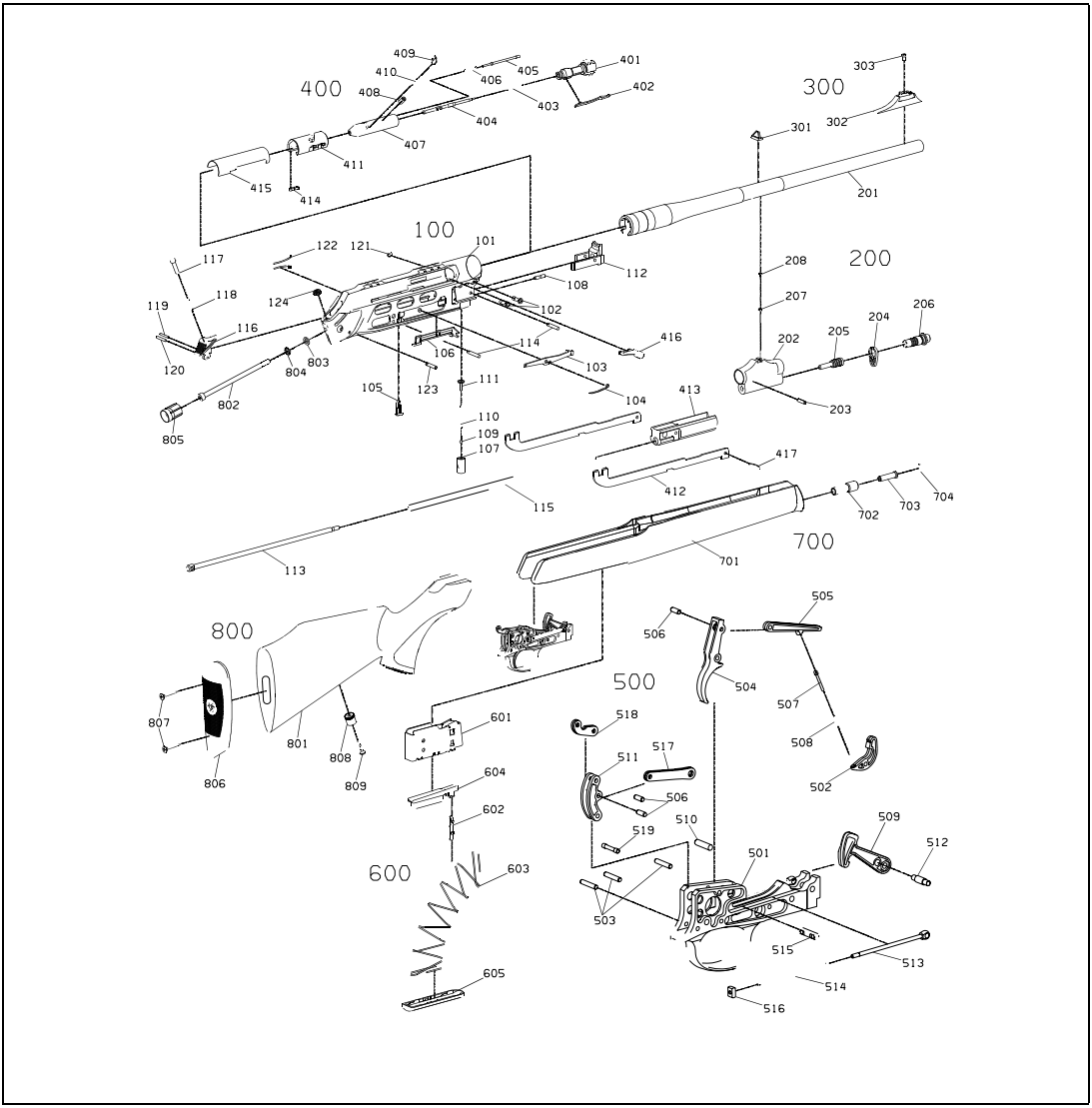

Fig. 31, pare parts for S 303 (Version with removable magazine)

15.2 Version with fixed fold out cover magazine

Item designation

100 Housing assembly
101 Housing, aluminum
102 2 clamping screws
103 Slide catch lever
104 Leaf spring f. slide catch
105 Lock f. slide catch
106 Magazine catch
107 Bolt for magazine catch
108 Locking pin
109 Ball
110 Pressure spring
111 Spring bolt
112 Insert with anti-squeal plate
113 Reverse recoil plug
114 2 straight pins
115 Action spring
116 Cocking slide
117 Bolt for cocking slide
118 Pressure spring
119 Heavy adapter sleeve
120 Straight pin
121 Bolt for barrel position
122 Spring for magazine ejection
123 Light dowel pin
124 Color insert, red

200 Barrel assembly
201 Barrel
202 Housing for gas cylinder
203 Heavy adapter sleeve
204 Bearing
205 Butt
206 Closing collet
207 Spring collet
208 Pan head screw

300 Rear & front sight assemblies
301 Aligning rear sight
302 Adjustable front sight

Item designation

303 Pan head screw

400 Slide assembly
401 Locking head
402 Extractor
403 Firing pin spring
404 Firing pin
405 Ejection rod
406 Ejector pin pressure spring
407 Bolt
408 Control bolt
409 Safety lock
410 Safety lock pressure spring
411 Control sleeve
412 2 slide rods
413 Slide weight
414 Slide lock
415 Cover sleeve
416 Loading lever
417 Clamp for weight

500 TriggerAssembly
501 Trigger housing
502 Latch
503 3 straight pins
504 Trigger
505 Safety lever
506 3 straight pins
507 Spring bolt
508 Magazine retaining spring
509 Hammer
510 Straight pin
511 Cocking lever
512 Bolt for hammer
513 2 spring bolts for mainspring
514 2 mainsprings
515 Bolt for chain
516 2 nuts
517 2 chains 36.7 mm
518 2 chains 16.3 mm

Item designation

600 Magazine assembly
601 Magazine case
602 Engaging piece for slide catch
603 Magazine spring
604 Feeder
605 Magazine floor plate

700 Front stock assembly
701 Front stock
702 Sling attachment bushing
703 Nut
704 Retainer ring

800 Main stock assembly
801 Main stock
802 Pan head screw
803 Washer
804 Crown gear
805 Retention sleeve
806 Butt
807 2 rounded head screw
808 Sling attachment bushing
809 Flat head wood screw
519 Pin

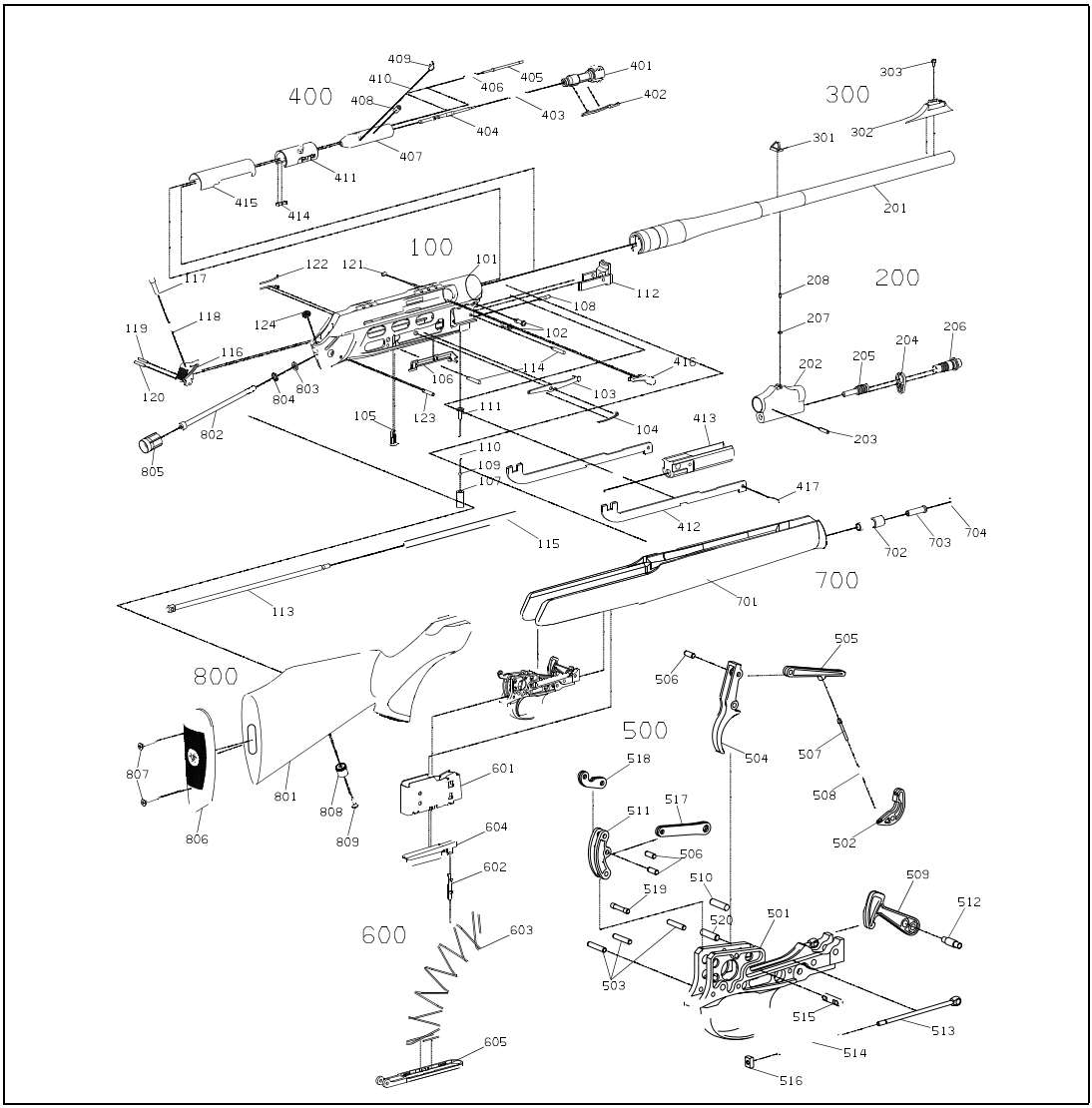

Fig. 32, Spare parts for S 303 (Version with fixed fold out cover magazine)

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